


6

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23329
<b>Description:</b> Hi-Step Leg Assembly	<b>Part Number:</b>	D2582
<b>Dwg:</b> D2582 Rev. A; D2322 Rev. C; D2279 Rev. D	<b>Qty:</b>	6
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller (minimum lots of 3015) <i>RF 02.10.22</i>	<i>RF</i>	05.05.20	20
2	MV	Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: <i>M17347</i>	<i>En</i>	05/06/16	30
3	MV	Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: <i>M17347</i>	<i>En</i>	05/06/16	30
4	MV	Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick (M5052H32S.080) Identify as D2278 Batch: <i>M17790</i> (Note: make two legs per assembly)	<i>En</i>	05/06/16	20
5	MV	Cut blank: (3.400") +/-0.020" Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1,000) Identify as D2280 Batch: <i>M11853</i> (Note: make two spacers per assembly)	<i>En</i>	05/06/16	20
6	MV	Machine as per folio D2322, use stack of 15	<i>En</i>	05/06/17	29
7	MV	Deburr to take measurement	<i>En</i>	05/06/17	29
8	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/17	29
9	QC8	Second inspection	<i>En</i>	05/06/17	29
10	MV	Machine as per folio D2279, use stack of 15	<i>En</i>	05/06/17	29
11	MV	Deburr to take measurement	<i>En</i>	05/06/17	30
12	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/17	30
13	QC8	Second inspection	<i>En</i>	05/06/17	30
14	MV	Machine as per folio D2278, use stack of 10	<i>En</i>	05/06/16	40
15	MV	Deburr to take measurement	<i>En</i>	05/06/16	40
16	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/16	40
17	QC8	Second inspection	<i>En</i>	05/06/17	40
18	MV	Machine per folio D2280 and Dwg D2280	<i>En</i>	05/06/17	40
19	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/06/17	40
20	MV	Tumble. Deburr any rough edges after tumbling.	<i>En</i>	05/06/17	40

RELEASED  
02/10/22 DF



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/07/06	29	Put Back in stock 9 of D2322 9 of D2279	SB	05/07/06	9		 05-07-06

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/17	#6	ONE Part (D2322) SCRAP wasnt against the Dowel.		scrap	 05/06/17	 05-06-17	 05/06/17	 05/06/17
05/06/17	#18	D2280 (4) SCRAP move in vise		destroy & replace	 05/06/17	 05-06-17	 05/06/17	 05/06/17
05/07/06	#23	<del>Put Back in Stock</del> <del>9 of D2322</del> <del>9 of D2279</del> D2279 over band						

Part No: D2582

PAR #:

Fault Category: Prod / FAB ABS

NCR: Yes No

DQA:

Date: 05/08/17

NOTE: Date & initial all entries

QA: N/C Closed:

Date: 05.08.17



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23329</b>
<b>Description:</b> Hi-Step Leg Assembly	<b>Part Number:</b>	<b>D2582</b>
<b>Dwg:</b> D2582 Rev. A; D2322 Rev. C; D2279 Rev. D	<b>Qty:</b>	<b>20</b>
Page 2 of 2		

Step	Location	Procedure	By	Date	Qty																												
21	QC8	Second inspection	me	05/06/17	40																												
22	GA	Deburr D2322, D2279 and D2278 stack	FF	05.07.4	42																												
23	GB	Bend D2322 and D2279 per Dwg D2322 and D2279	FF	05.07.4	27																												
24	QC5	Inspect work to Step 23	J	05-07-04	27																												
25	FP	Chemical conversion as per QSI 005 D2278, D2279, D2280, D2322	FF	05-07-05	18																												
26	GA	Assemble as per Dwg D2582 and <b>Identify as D2582 Assembly</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2278</td><td>Leg</td><td>B23329</td></tr><tr><td>1</td><td>D2279</td><td>Spacer</td><td>B21869A</td></tr><tr><td>2</td><td>D2280</td><td>Spacer</td><td>B23329</td></tr><tr><td>1</td><td>D2322</td><td>Spacer</td><td>B23329</td></tr><tr><td>22</td><td>MS20470AD4-4</td><td>Rivet</td><td>M16199</td></tr><tr><td>4</td><td>MS20470AD4-5</td><td>Rivet</td><td>M16163</td></tr></table>	Qty	Part Number	Description	Batch	2	D2278	Leg	B23329	1	D2279	Spacer	B21869A	2	D2280	Spacer	B23329	1	D2322	Spacer	B23329	22	MS20470AD4-4	Rivet	M16199	4	MS20470AD4-5	Rivet	M16163			
Qty	Part Number	Description	Batch																														
2	D2278	Leg	B23329																														
1	D2279	Spacer	B21869A																														
2	D2280	Spacer	B23329																														
1	D2322	Spacer	B23329																														
22	MS20470AD4-4	Rivet	M16199																														
4	MS20470AD4-5	Rivet	M16163																														
27	QC5	Inspect work to Step 26	me	05/08/22	6																												
28	GA	Identify and Stock	J	05-08-26	6																												
29	AC	Cost / part 82.02	SAC	05-09-02	6																												
30	DC	Close W/O 82.02 Inspect Level 21	D	05/08/27	6																												

Rev	Date	Change	Revised By	Approved
A	96.07.08	New Issue		
B	99.02.10	Re-format	DM	
C	01.10.16	Added new rivet and new dwg (mpp2165)	SM	
D	02.05.14	Added rivet option	NG	
E	02.10.07	Re-format; Incorporated D2278, D2279, D2280, D2322	KJ RF	

RELEASED  
02/10/22 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_























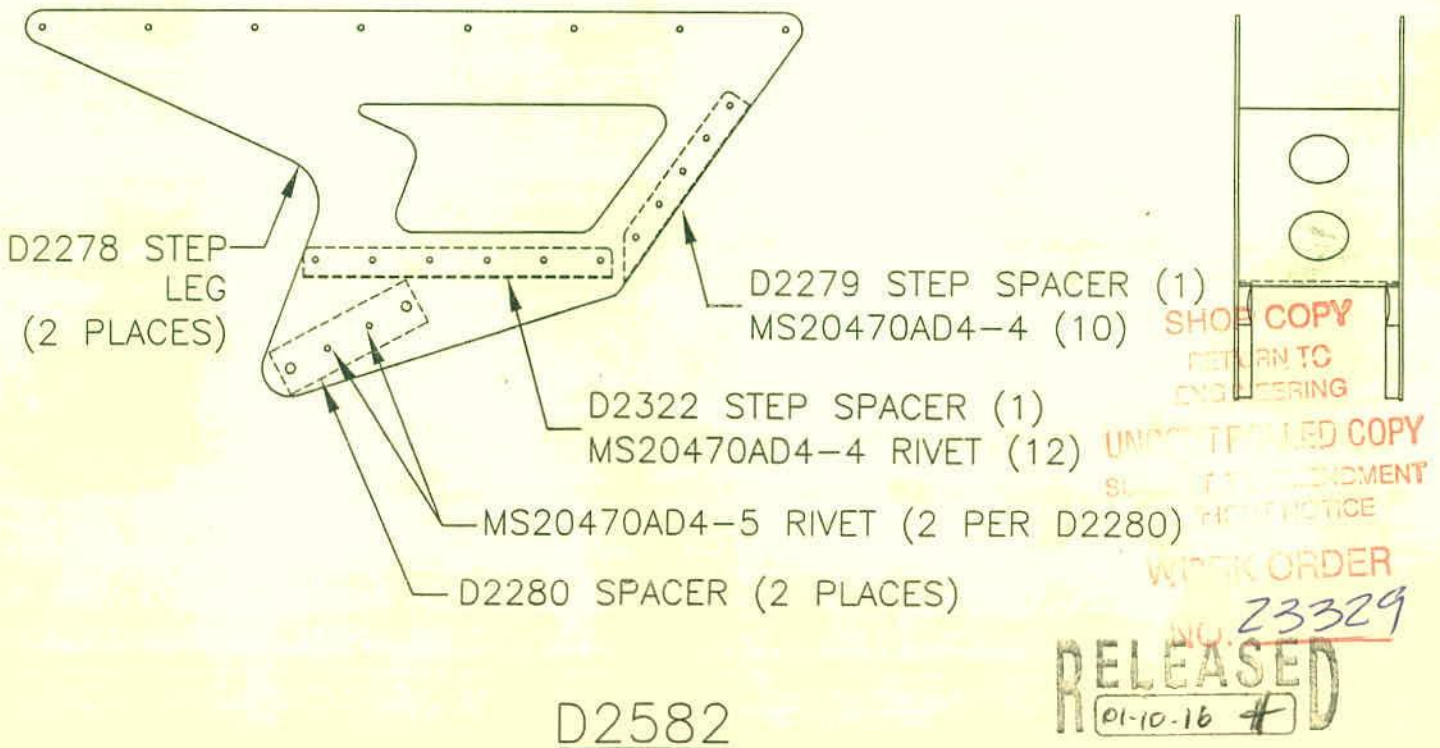






DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2582	REV. A SHEET 1 OF 1
DATE 01.10.05		TITLE STEP LEG ASSEMBLY	SCALE 1:5
A	01.10.05	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET



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DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29		TITLE STEP SPACER	SCALE 1:2
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

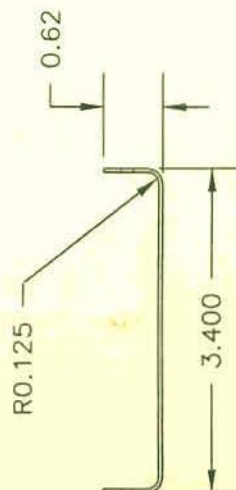
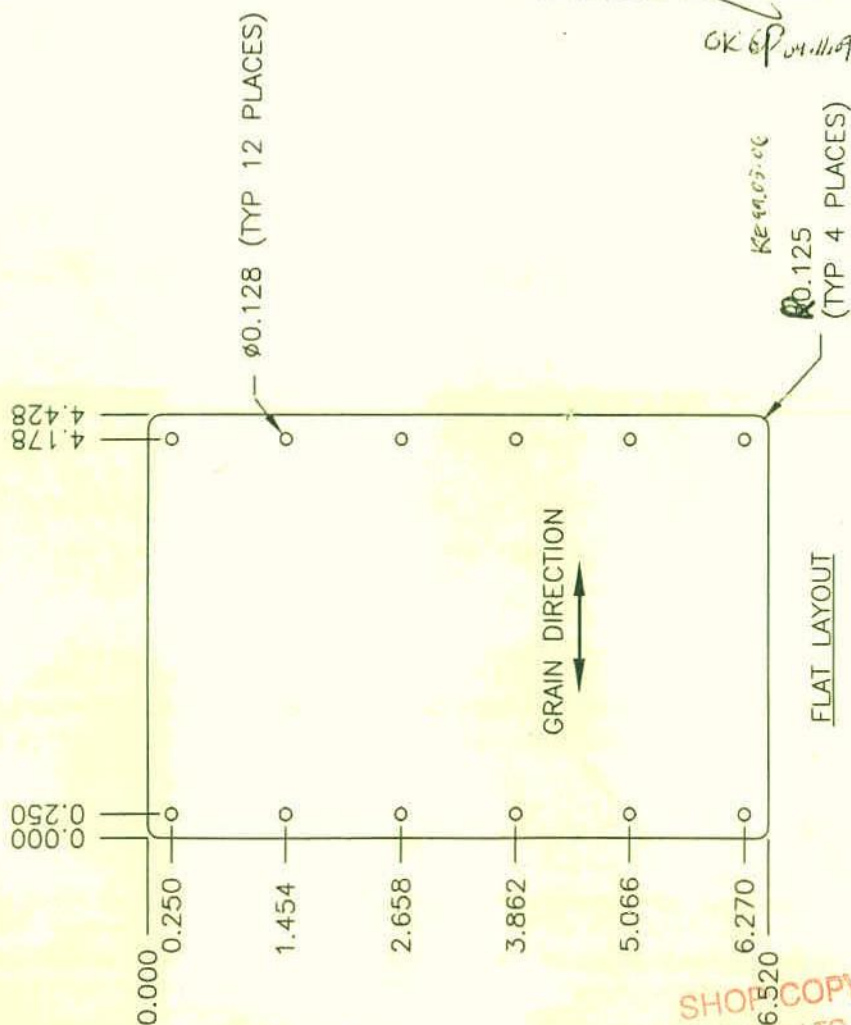
RELEASED  
98.10.08 DS

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
DS BEFORE MANUFACTURE

OK 6P 04.11.99



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

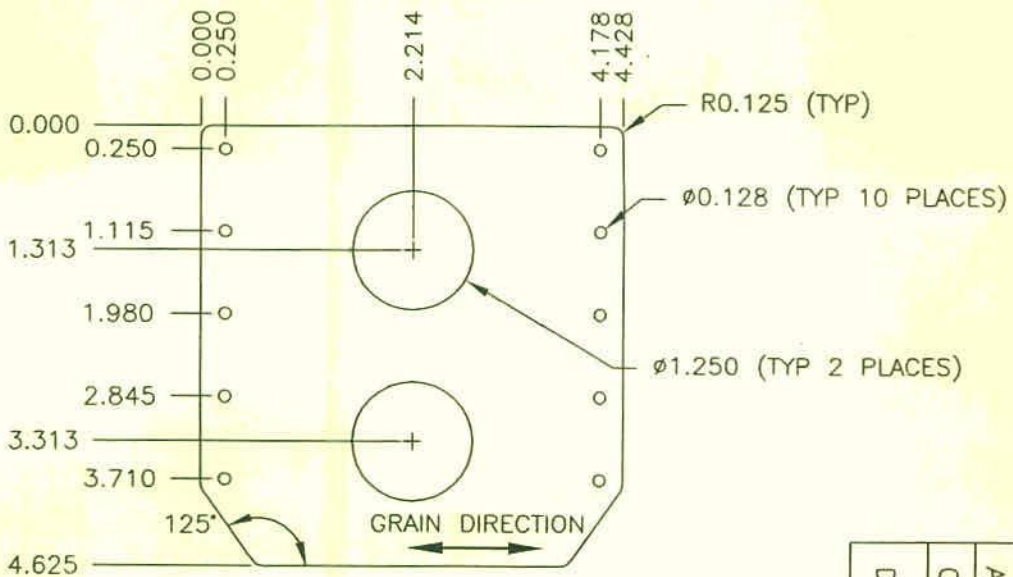
SHORT COPY  
RETURN TO  
ENGINEERING  
UNIDENTIFIED COPY  
SUBMIT TO INVENT  
WITHOUT  
WORK ORDER  
NO. 23329



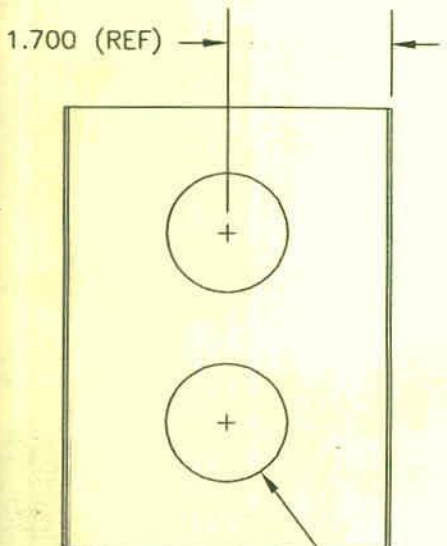




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	HA	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



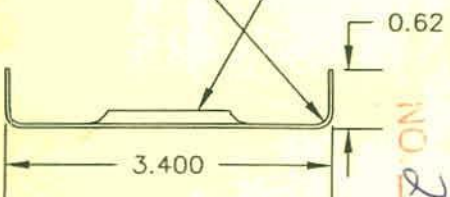
FLAT LAYOUT



1.700 (REF)

FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)

R0.125

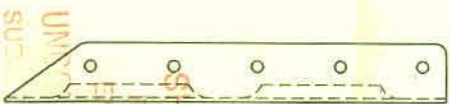


UNDER REVIEW

RELEASED  
48.10.08 DS

DESIGN OK, BUT CHECK WITH  
TS BEFORE MANUFACTURE

OK 4/11/08



WORK ORDER  
NO 23329

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED







DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2280	REV. C SHEET 1 OF 1
DATE 98.09.29	TITLE SPACER		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
CP# 1	01-10-05	ADD CUSING & KNURLING	

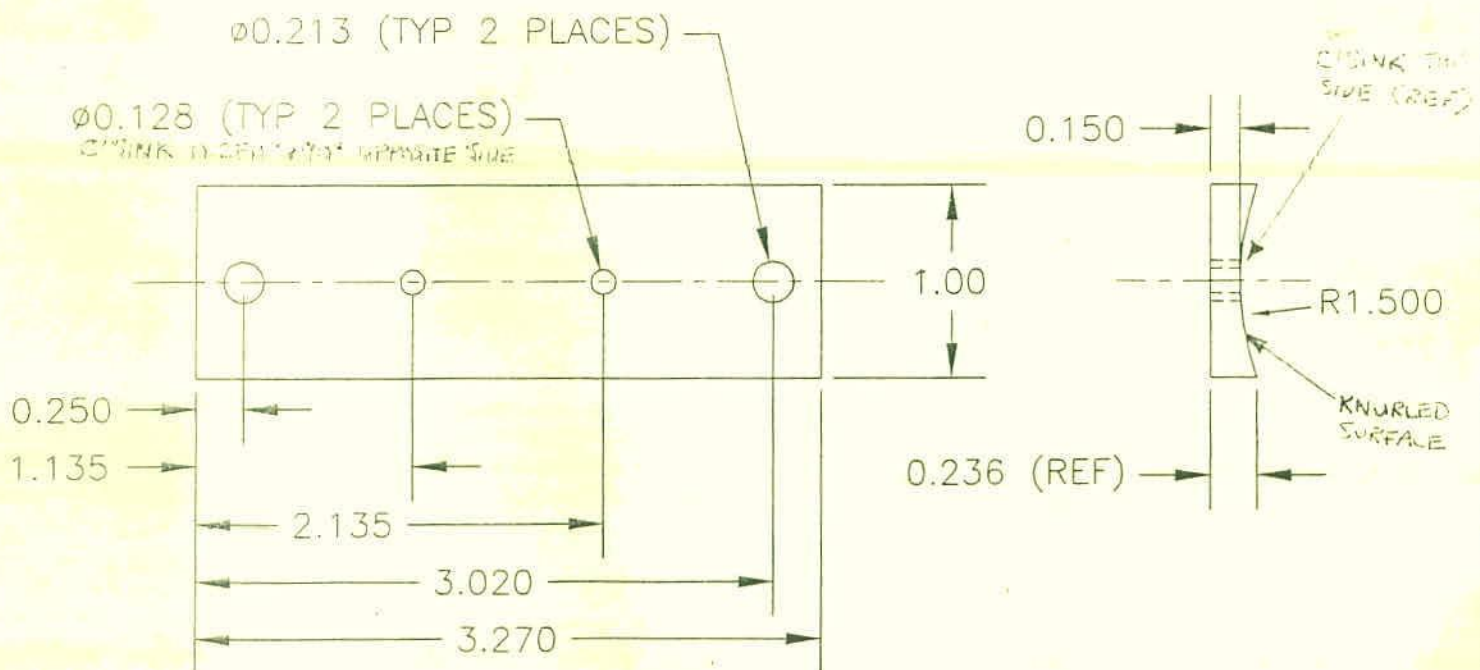
RELEASED  
*[Signature]*

UNDER REVIEW

01.03.15 CP

DESIGN ON BUT NOT FOR  
DISTRIBUTION MANUFACTURE

CONTROLLED COPY



MATERIAL: 6061-T6 (QQ-A-200/8) 0.25 x 1.00

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

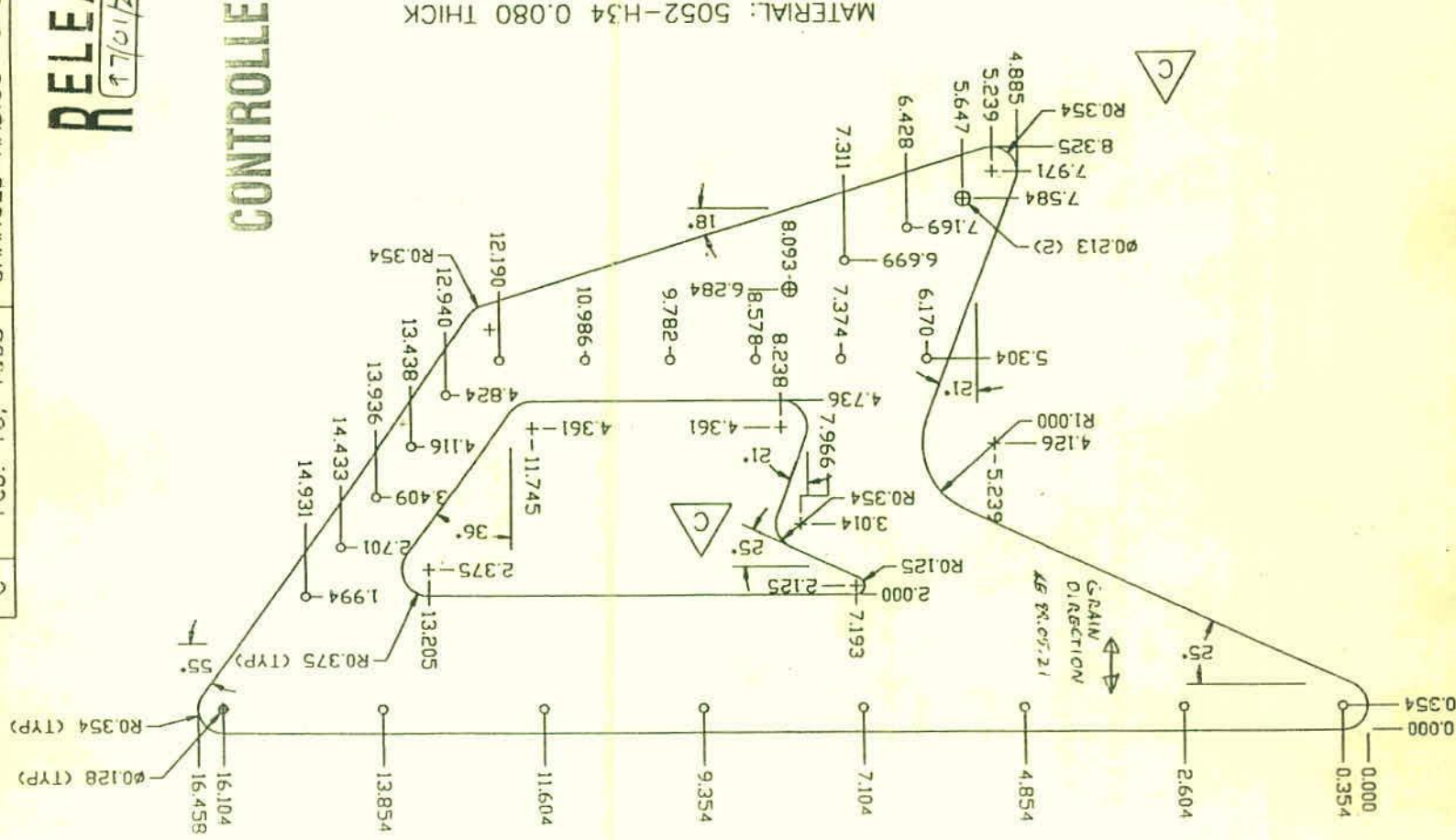






PREPARED		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
B. Williams	APPROVED	D2278	REV. C
CHECKED			SHEET 1 OF 1
DATE		TITLE	SCALE
Oct. 13, 1994		LEG	1:2.5
C	Feb. 16, 1995	CHANGED RADIUS TO 0.354	

UNDER REVIEW  
DRAFTS CP  
Design OK, BUT CHECK WITH  
DR. BEFORE MANUFACTURE



RELEASED  
R 170127 00

CONTROLLED COPY





# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 17, 2005  
10:51 am

Work Order No : 0023329  
Project Name : D2582  
Project For : WK524  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2582  
Description : Hi-Skid Step Leg Ass'y  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 05-16-05  
Est Finish Date : 06-16-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00